

54401 Derev

Work Order ID 53882



Page 1

November 23, 2009 11:21:49 AM

Item ID: D3065-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Leg

Start Date: 23/11/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 80.00

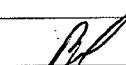


Customer:

Reference:

Approvals:

Process Plan:



Date: 27/11/2009

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3065	Rev B
-------	-------

100



FLOW WATER JET

Waterjet

Memo

0.00

1-Cut as per Dwg D Dwg Rev: B Prog Rev: B 2-Deburr if necessary

HB 9-12-3

88

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

HB 9-12-3

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Countup
488

2) 2012/04
QSP019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53882

November 23, 2009 11:21:49 AM



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Item Name: Step Leg

Start Date: 23/11/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 80.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
					Run Stop
	QC:	Date:	SPC (Y/N):	Date:	Run Stop

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Chemical Conversion Coat per QSI005 4.1 HandFinish	0.00 0.00	<i>BR 09/12-7</i>						

HandFinishing
Hand Finishing

140 	QC3- Inspect Part Finish QC	0.00	<i>23/11/08</i>
	Memo	0.00	

Quality Control

*Counted
K&G
11/12/08*

150 	Identify as per dwg & Stock Location: Packaging	0.00	<i>Cap/88-88</i>
	Memo	0.00	

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53882

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November 23, 2009 11:21:49 AM

Item ID: D3065-5

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Setup Start



Revision ID: B

Stop



Item Name: Step Leg

Start Date: 23/11/2009 Start Qty: 80.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/12/08 JG

MF
09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 11:21:55 AM

Page 1

Work Order ID: 53882



Parent Item: D3065-5RevB



Parent Item Name: Step Leg

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	161.3809	90.9305	100.0008		

6061-T6 .080 Sheet

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	161.38087	
107904	0.02	
110254	1.5	
110630	33.5136	
112040	0.0437	
112141	9	
112512	0.2784	
112763	117.02517	

$$\begin{aligned}
 107904 \times 1 &= 1.1360 \\
 110254 \times 1 &= \\
 112040 \times 1 &= \\
 112141 \times 1 &= \\
 112512 \times 1 &= \\
 112763 \times 83 &= 94.3403
 \end{aligned}$$

82.025
17

2784

9.

0437

1.500

.0200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53888
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 9-12-3	Date: 09/12/14	Date: N/A

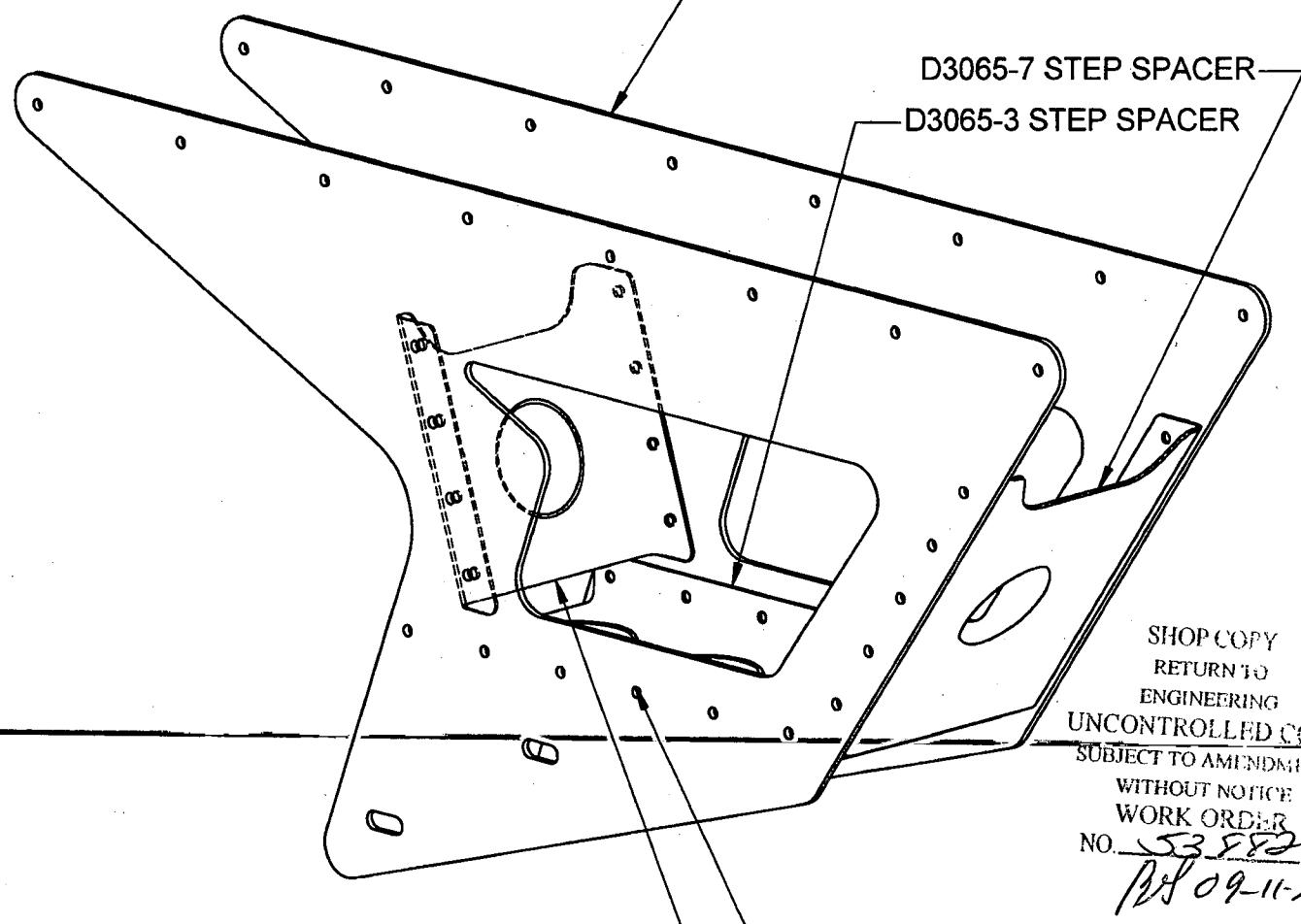
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH		D3065	SHEET 1 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 ✓

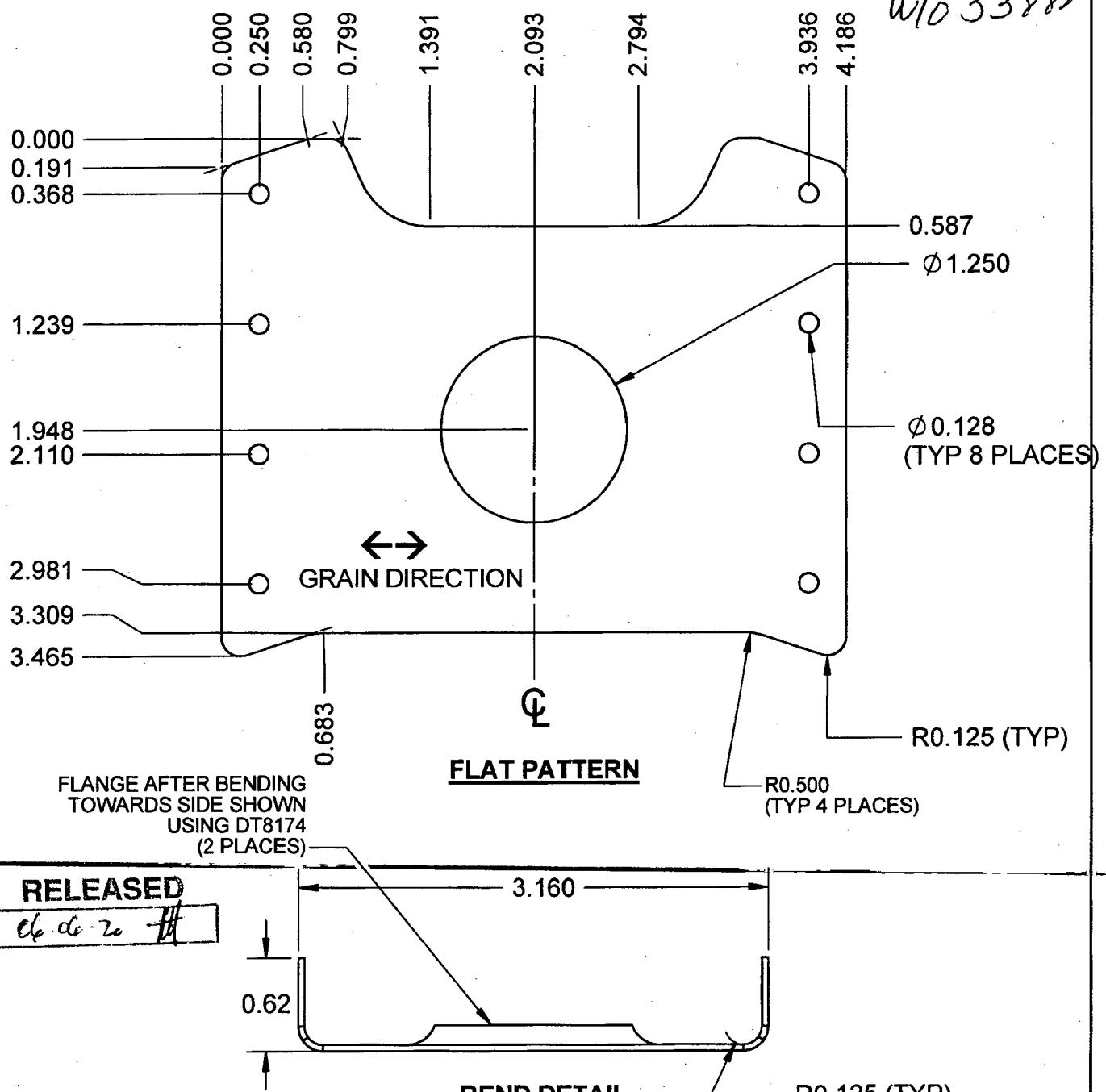
D3065-5 STEP LEG (2 PLACES)**D3065-7 STEP SPACER****D3065-3 STEP SPACER****D3065-041 STEP LEG ASSEMBLY**

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH		D3065	SHEET 2 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:1

**D3065-1 STEP SPACER**

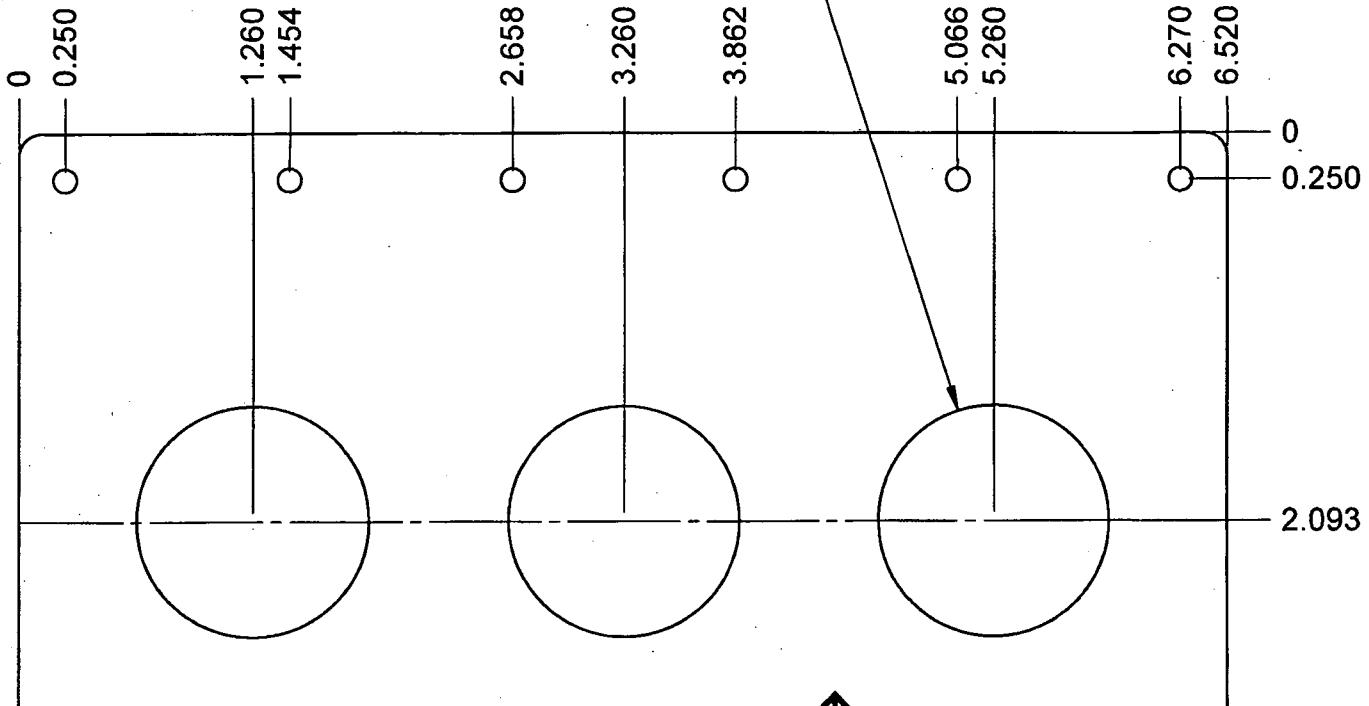
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

 $\phi 1.250$ (TYP, 3 PLACES)*W10 53 882***FLAT PATTERN****GRAIN DIRECTION**FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$ (TYP, 12 PLACES)**RELEASED***06 ok 20 - MM*

3:160

0.62

BEND DETAIL

R0.125

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

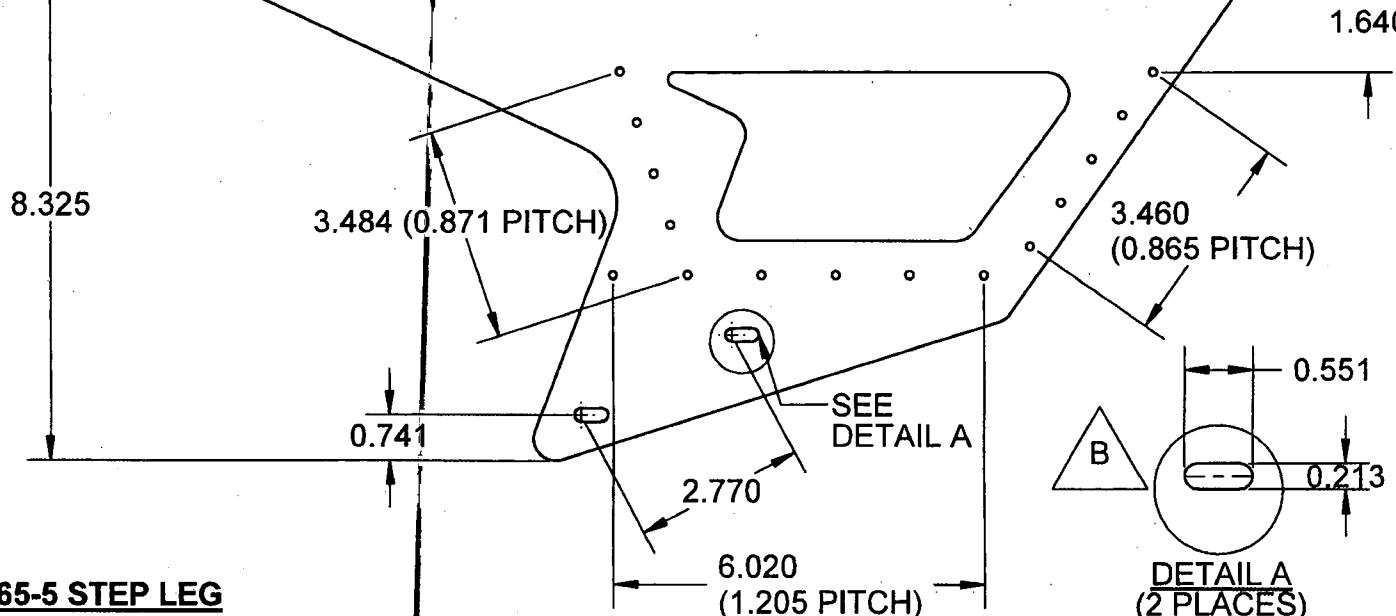
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DART

DESIGN	<i>IP</i>	DRAWN BY	<i>C.B</i>	DART AEROSPACE LTD
CHECKED	<i>PH</i>	APPROVED	<i>JK</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B

16.458
15.750 (2.250 PITCH)
 $\phi 0.128$ (DRILL #30)
(TYP 23 PLACES)

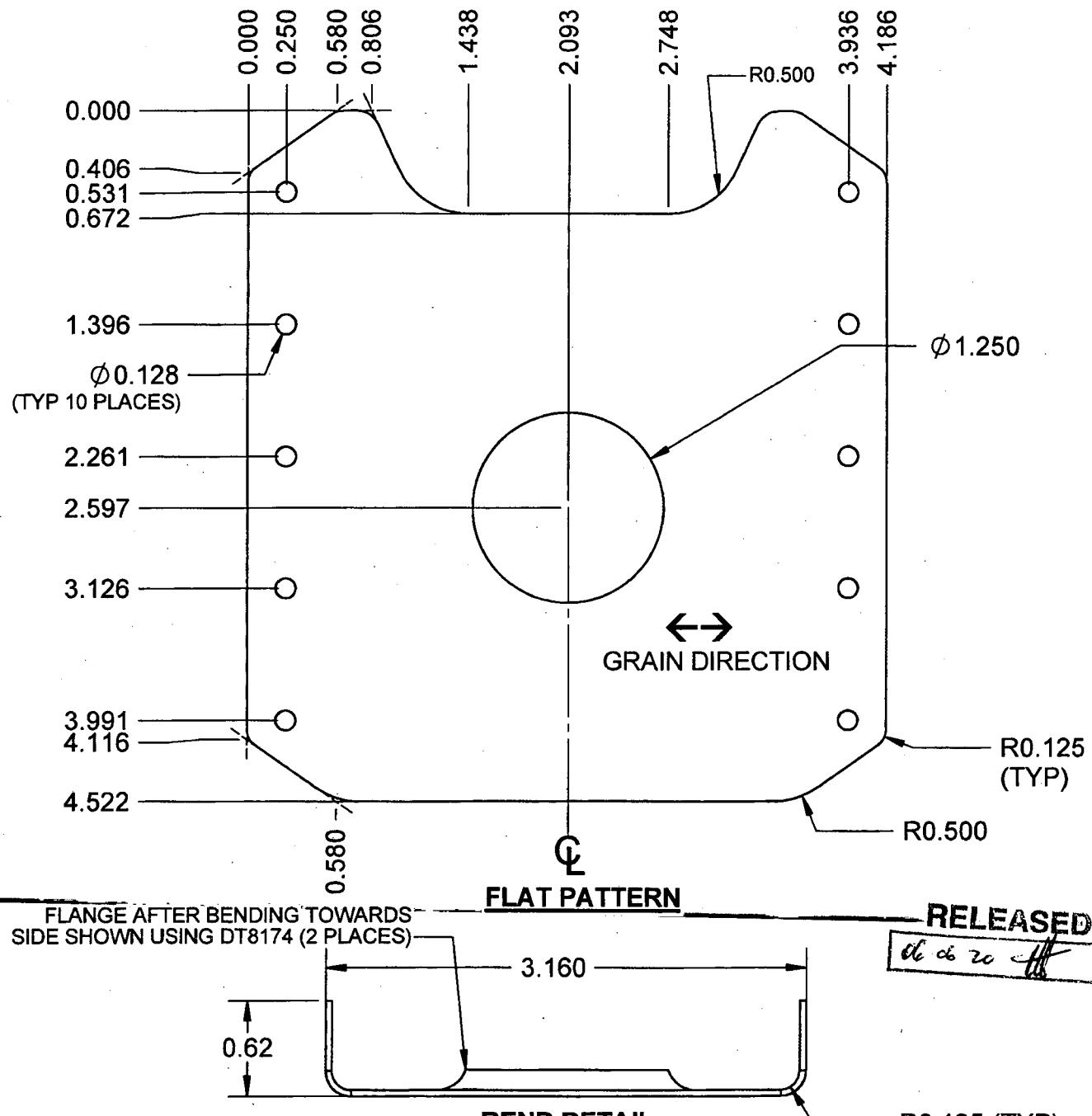


D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3065	REV. B	SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE	1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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